

# Work Order ID 73053

Wednesday, August 24, 2011 3:35:10 PM



Page 1

Item ID: D2065

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 8/25/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: MUF Date: 11-08-24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2065	Rev C								

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012.  
Note: 1 end only  
2-Cut to length as per Dwg D2065  
3-Form as per Dwg D2065 and template DT8251  
4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template

*Handwritten signature and date: 8/24/08/30 (5)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Handwritten date: 8/26/08/31*

*Handwritten initials: TS*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73053**

Wednesday, August 24, 2011 3:35:10 PM



Page 3

Item ID: D2065

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 8/25/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/9/6   
ME  
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 24, 2011 3:35:08 PM

Page 1

Work Order ID: 73053

Parent Item: D2065

Parent Item Name: Arm



Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: E02.04.15 Added Dwg Rev.B1 NG  
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.500W.049

Purchased

No

120

f

256.0684

1.7

8.947368



304 RD Tube .500 x .049W



*Handwritten signature and date: 8/24/08/30*

Location

Loc Qty

Loc Code

MAT017

256.068426

111814

2.23

115010 -

154.368426

117598

99.47

8.947368

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

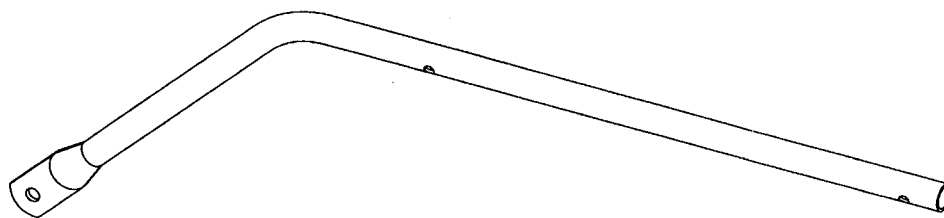
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2065 ARM**

#73053

**RELEASED**  
08.07.13

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A5-2); ADD D2065F CUT LENGTH DETAIL FOR D2085 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE		PH	08.06.13
B	RE-DESIGN		BW	96.02.06
A	NEW ISSUE		BW	92.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D2065	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		ARM	NTS	
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

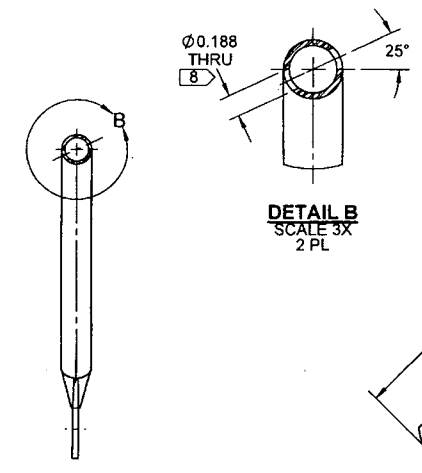
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

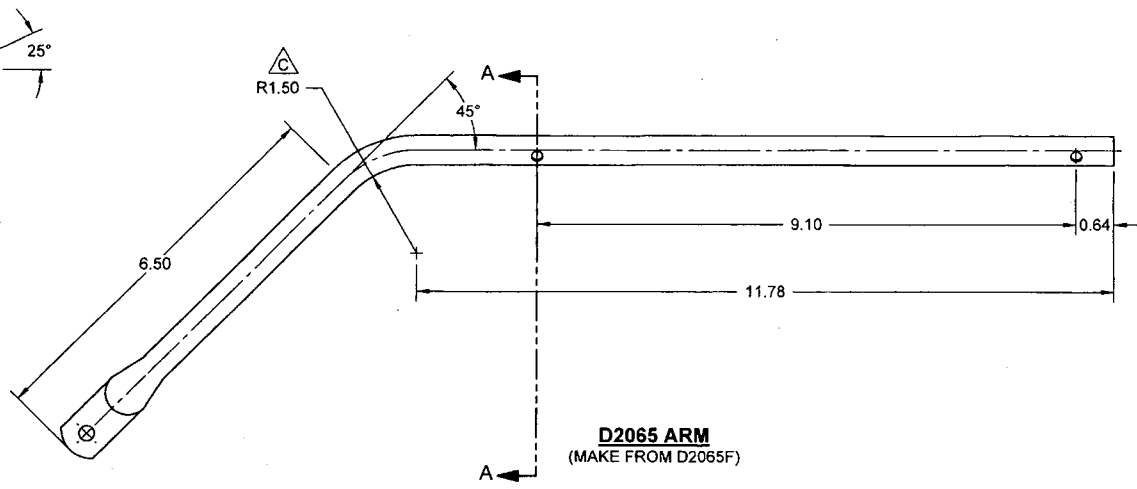
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

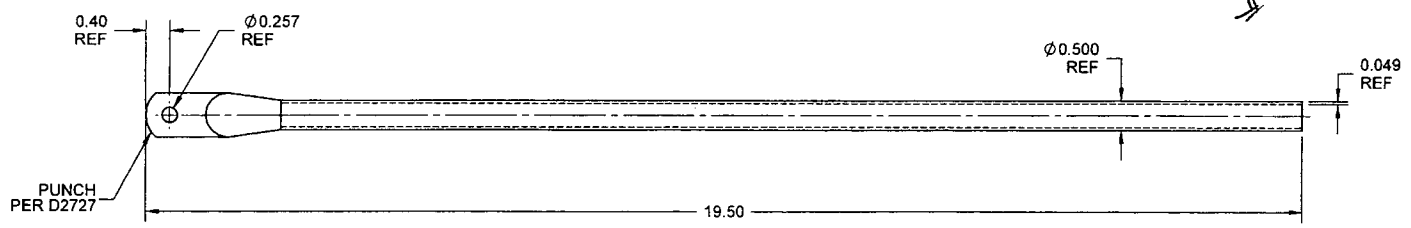
**SECTION A-A**



**DETAIL B**  
SCALE 3X  
2 PL



**D2065 ARM**  
(MAKE FROM D2065F)



**D2065F ARM CUT LENGTH DETAIL**

*73053*

**RELEASED**  
08-07-2013

- NOTES:**
- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.41 lbs
  - 8) DRILL  $\phi 0.188$  AFTER BENDING

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO. D2065	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		ARM	SCALE
DE APPR.			NTS
DATE	08.06.13	<small>COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries